

# Work Order ID 123748

**\*123748\***

Page 1

Tuesday, August 19, 2014 1:13:04 PM

Item ID: D3119-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Cover Assembly  
 Start Date: 8/19/2014 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 8/22/2014 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: MF Date: 14-8-19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3119	Rev B								

100 PURCHASING 0.00  
**\*100\***  
 Purchasing Memo 0.00  
 Purchasing Issue P/O: 25554  
 Manufacture D3119-041 Cover Assembly as per Dwg D3119  
 (2x D3119-3 window)  
 Supplier: Delastek  
 Material: Cream Kydex 100, 0.060 thick  
 Material release note required

CL 14/08/27 4

110 Receive & Inspect for Damage & Mat'l Certs 0.00  
**\*110\***  
 Packaging Memo 0.00  
 Packaging Ensure Material Release Note is attached

CL 14/11/18 4

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty.	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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# Work Order ID 123748

**\*123748\***

Page 2

Tuesday, August 19, 2014 1:13:04 PM

Item ID: D3119-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Cover Assembly  
 Start Date: 8/19/2014 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 8/22/2014 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							DAS 38 9-89
<b>*120*</b>						(4)			
QC	Memo	0.00							
Quality Control									NOV 20 2014
130	Identify as per dwg & Stock Location: CA	0.00							
<b>*130*</b>						4x			DAS 28 9-89
Packaging	Memo	0.00							NOV 21 2014
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									14/11/24
QC	Memo	0.00							
Quality Control									

24-11-21

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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Tuesday, August 19, 2014 1:13:03 PM

Page 1

**\*123748\***

**\*D3119-041\***

**Start Date:** 8/19/2014

**Required Date:** 8/22/2014

**Start Qty: 4.00**

**Required Qty: 4.00**

**Comments:** IPP: A03.02.24New IssueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3119-041P		Purchased	No			110	Each	0.0000	1	4			
*D3119-041P*									**	C21411118			
Cover Assembly													

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

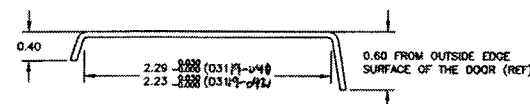
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng.	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

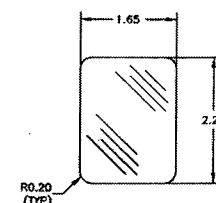
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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RELEASED  
04.11.23



SECTION A-A



D3119-3 WINDOW

#123748

D3119-1 COVER, LH (SHOWN, REPLACES PREMIER P/N B30-23000-219)

- 1) MAKE FROM TOOL B30-23000-219T
- 2) MATERIAL: CREAM KYDEX 100, 0.060 THICK

D3119-2 COVER, RH (OPPOSITE, REPLACES PREMIER P/N B30-23000-220)

- 3) MAKE FROM TOOL B30-23000-220T
- 4) MATERIAL: CREAM KYDEX 100, 0.060 THICK

D3119-3 WINDOW (REPLACES PREMIER P/N B30-23000-221)

- 5) MATERIAL: LEXAN, 0.060 THICK

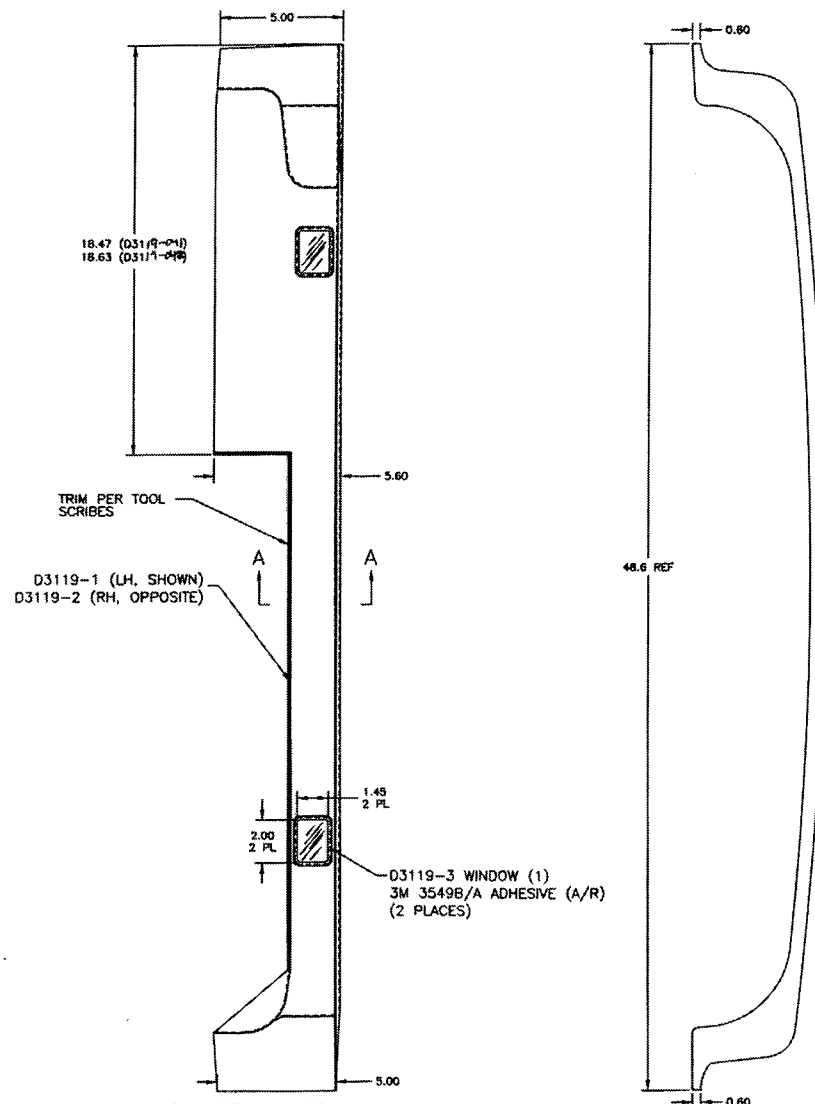
GENERAL NOTES

- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

B	04.11.17	RE-DESIGN
A	02.04.15	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3119
DATE	04.11.17	TITLE COVER ASSEMBLY
		REV. B SHEET 1 OF 1 SCALE NTS

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D3119-041 COVER ASSEMBLY, LH  
(SHOWN, REPLACES PREMIER P/N B30-23000-29)

D3119-042 COVER ASSEMBLY, RH  
(OPPOSITE, REPLACES PREMIER P/N B30-23000-30)

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Training									
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### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO25554

Purchase Order Date 8/27/2014

PO Print Date 8/27/2014

Page Number 1 of 2

**Order From :**

VU-DEL003

**Ship To :** DART AEROSPACE LTD

DELASTEK INC  
2699 5E AVENUE, LOCAL C.P 10100  
  
GRAND-MERE, QC G9T 5K7  
CA

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name**

**Vendor Phone** 819 533 5788

**Ship To Contact**

**Ship To Phone**

**Ship Via:** FedEx Overnight collect

**Ship Acct:**

**Buyer**

Chantal Lavoie

**Customer POID**

**Customer Tax #**

10127-2607

**Terms**

Net 30

**Currency**

USD

**FOB**

FCA - (Free Carrier)

**PAID**

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3119-041P  AS PER DWG D3119 REV. B B123748 MATERIAL: CREAM KYDEX 100, 0.060" THICK	Cover Assembly	<del>9/19/2014</del> Yes <del>9/19/2014</del> 10/27		4.00 ✓ Each	\$112.62	\$450.48
<b>Line Total:</b>							<b>\$450.48</b>
2	D3119-042P  AS PER DWG D3119 REV. B B122984 MATERIAL: CREAM KYDEX 100, 0.060" THICK	Cover Assembly	<del>9/19/2014</del> Yes <del>9/19/2014</del> 10/27		2.00 ✓ Each	\$112.62	\$225.24
<b>Line Total:</b>							<b>\$225.24</b>

021411118

Note:

8/27/2014



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO25554**

Purchase Order Date 8/27/2014

PO Print Date 8/27/2014

Page Number 2 of 2

**Order From :**

VU-DEL003

DELASTEK INC  
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7  
CA

**Ship To :** DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name**

**Vendor Phone** 819 533 5788

**Ship To Contact**

**Ship To Phone**

**Ship Via:** FedEx Overnight collect

**Ship Acct:**

**Buyer**

Chantal Lavoie

**Customer POID**

**Customer Tax #** 10127-2607

**Terms** Net 30

**Currency** USD

**FOB** FCA - (Free Carrier)

3	71401-45	PROCUREMENT QUALITY CLAUSES	9/19/2014	1.00		\$0.00	\$0.00
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No

Procurement Quality Clauses  
A004 faa-pma/tso  
A005 right of entry  
A016 personnel qualification  
A025 certification of conformance  
A040 notification of quality escape  
A041 quality management  
A042 dart notification by supplier  
A043 retention of quality documents

9/19/2014

**Line Total:** \$0.00

**PO Total:** \$675.72

CX

**Note:** Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

**Change Nbr:** 1

**Change Date:** 8/27/2014

**DELASTEK**

DELASTEK Inc.  
2699 5e Avenue  
Local 14,  
Grand-Mère, Québec G9T 2P7  
Canada  
Tel.: (819) 533-5788  
Fax: (819) 533-3494

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	58798
Customer No.	DART US


**Bill To**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

**Ship To**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-9577  
Contact : Chantal Lavoie

Ship Date	Order Date	Our SO #	Ordered by	Your PO #	Terms
17-11-2014	08-09-2014	24973	Chantal Lavoie	PO25554	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
FEDEX P1 Collect		Point de départ		Melody Shapcott, ext. 235	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
4	0	4	DKC135-0001	Line #1 D3119-041 Cover Assy B123748 U of M: Chaque Dwg Rév.: B	
				Lot #	
				65365	1
				65456	3
2	0	2	DKC135-0002	Line #2 D3119-042 Cover Assy B122984 U of M: Chaque Dwg Rév.: B	
				Lot #	
				65366	2
DOCUMENT INCLUS 					

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

  
Quality department  AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Jeudi, 2014-10-30 15:50:09  
Utilisateur: Véronique Bouchard

Feuille de Procédé

ASAP

Cliant : DART US DART AEROSPACE  
Numéro Job : 65365  
Numéro : 4138  
Numéro B.A. :  
Cette fois : 2014-10-30 No. :  
Prsht Rev. : NC  
Prem. fois : - - Type :  
Job précédente : 56939

Nom Dessin : COVER ASSY  
Numéro Article : DKC135-0001  
Numéro Dessin : D3119  
Projet Numéro : DKC135  
Révision dessin : B  
Matériel : Kydex 100 beige .060" Thk  
Date Dûe : 2014-11-06 Qté: 1 Ud UNITE



Écrit par :  
Vérifié & Approuvé par :  
Commentaires : N° de pièce Dart Aerospace: D3119-041  
N° de pièce Delastek Aeronautique: DKA359-0005  
N° de pièce Delastek Composites: DKC135-0001

Feuille de procédé Rév.: 01 Changer la taille du matériel au thermoformage 16"x 62" x 0.60 Thk modifié pour 23" x 68" x 0.60 Thk., AMB0208 changé de .36 à .5

Formulaire d'inspection: N/A

COPIE

Produit additionnel

Numéro Job:



# Séq.: Machine ou Description :

1.0 AMB0208 Kydex 100 cream 0.060"thick # 72005

Comment Qty.: 0.50 FEUILLE(s)/Unit Total : 0.50 FEUILLE(s)

Kydex 100 cream 0.060"thick

N° de Lot :

4846010AA

2.0 THERMOFORMAGE Thermoformage / Découpe primaire



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Thermoformage des pièces.

Monter le set-up du moule de thermoformage N° DKG 359-504 sur le thermoformeur 4' x 8'.

Tailler le matériel selon les dimensions requises :  
23" x 68" x .060" Thk.

Thermoformer la pièce B30-23000-219.

Autocontrôle de fabrication. (Visuel et épaisseur)

Quantité : 1 Date : 31/10/14 Sceau :



Quantité : Date : Sceau :

Date: Jeudi, 2014-10-30 15:50:09

Utilisateur: Véronique Bouchard

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 65365

Nom Dessin: COVER ASSY  
Numéro DKC135-0001

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

3.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Trimage de finition

Faire le découpage primaire sur la scie à ruban.

Faire le trimmage de la pièce selon la ligne tracée sur le moule (elle doit apparaître sur la pièce) et selon le dessin page 21 (Pour les trous).

Autocontrôle de fabrication. (Visuel et selon le moule)

Déburrer.

Quantité : 1 Date : 10-11-14 Sceau :

Quantité : \_\_\_\_\_ Date : \_\_\_\_\_ Sceau : \_\_\_\_\_

4.0

AMB0209

Lexan 9034 transparent 0.060" thickness

Comment Qty.: 0.001 FEUILLE(s)/Unit Total : 0.001 FEUILLE(s)

Lexan 9034 0.060" thickness

N° de Lot : 4774410 1A

5.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Taillage du matériel.

Sur la banc scie, tailler les B30-2300-221 selon les dimensions du dessins (1.65" x 2.20") et faire des rayons de .20" au quatre coins.

Ébavurer.

Autocontrôle de fabrication. (Visuel et selon le dessin)

Quantité : 1 Date : 10-11-14 Sceau :

Quantité : \_\_\_\_\_ Date : \_\_\_\_\_ Sceau : \_\_\_\_\_

Date: Jeudi, 2014-10-30 15:50:09  
Utilisateur: Véronique Bouchard

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 65365

Nom Dessin: COVER ASSY  
Numéro DKC135-0001

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

6.0 AAC0562

3549 B/A adhesive kit 2oz.

Comment Qty.: 0.01 UNITE(s)/Unit Total: 0.01 UNITE(s)

3549 B/A adhesive kit 2oz.

N° de Lot :

4184401A1

7.0 PRÉPARATION.

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs

Faire le mélange de l'adhésif 3549 B/A selon les instructions inscrites sur le contenant.

Date: 11-1-14

Sceau :



8.0 ASSEMBLAGE

Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Assemblage général des pièces

Assembler les deux B30-23000-221 Window sur le B30-23000-219 à l'aide de l'adhésif 3549 B/A et laisser sécher pendant 16 heures.

Autocontrôle de fabrication. (Assemblage)

Quantité : 1

Date : 13-11-14

Sceau :



Quantité :

Date :

Sceau :

9.0 INSPECTION

Inspection générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire l'inspection de la pièce selon le dessin.

Quantité : 31

Date : 14-11-14

Sceau :



Quantité :

Date :

Sceau :

Date: Jeudi, 2014-10-30 15:50:09  
Utilisateur: Véronique Bouchard

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 65365

Nom Dessin: COVER ASSY  
Numéro DKC135-0001

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

10.0

IDENTIFICATION

Identification des pièces



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Identification des pièces.

Faire l'identification : N° de pièce : D3119-041

Date de fabrication : 14-11-14

N° de Work Order: 65365

Sceau d'inspection

Autocontrôle de fabrication. (Visuel de l'identification)

Quantité : 1 Date : 14-11-14 Sceau :

Quantité : Date : Sceau :

11.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer les pièces selon IG 0057.

Quantité : 1 Date : 14-11-14 Sceau :

Date: Jeudi, 2014-11-06 11:50:16  
Utilisateur: Véronique Bouchard

## Feuille de Procédé

ASAP

<b>Client</b>	: DART US DART AEROSPACE	<b>Nom Dessin</b>	: COVER ASSY
<b>Numéro Job</b>	: 65456	<b>Numéro Article</b>	: DKC135-0001
<b>Numéro</b>	: 4138	<b>Numéro Dessin</b>	: D3119
<b>Numéro B.A.</b>	:	<b>Projet Numéro</b>	: DKC135
<b>Cette fois</b>	: 2014-11-06 <b>No.</b> :	<b>Révision dessin</b>	: B
<b>Prsht Rev.</b>	: NC	<b>Matériel</b>	: Kydex 100 beige .060" Thk
<b>Prem. fois</b>	: - - <b>Type</b> :	<b>Date Dûe</b>	: 2014-11-13 <b>Qté:</b> 3 Ud UNITE
<b>Job précédente</b>	: 56939		



**Écrit par** : \_\_\_\_\_  
**Vérifié & Approuvé par** : \_\_\_\_\_  
**Commentaires** : N° de pièce Dart Aerospace: D3119-041  
 N° de pièce Delastek Aeronautique: DKA359-0005  
 N° de pièce Delastek Composites: DKC135-0001

Feuille de procédé Rév.: 01 Changer la taille du matériel au thermoformage 16"x 62" x 0.60 Thk modifié pour 23" x 68" x 0.60 Thk., AMB0208 changé de .36 à .5

Formulaire d'inspection: N/A

COPIE

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
---------	------------	---------------

1.0	AMB0208	Kydex 100 cream 0.060"thick # 72005
-----	---------	-------------------------------------

**Comment** Qty.: 0.50 FEUILLE(s)/Unit Total : 1.50 FEUILLE(s)

Kydex 100 cream 0.060"thick

N° de Lot:

4846010AA

2.0	THERMOFORMAGE	Thermoformage / Découpe primaire
-----	---------------	----------------------------------



**Comment** Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs


Thermoformage des pièces.

Monter le set-up du moule de thermoformage N° DKG 359-504 sur le thermoformeur 4' x 8'.

Tailler le matériel selon les dimensions requises :  
23" x 68" x .060" Thk.

Thermoformer la pièce B30-23000-219.

Autocontrôle de fabrication. (Visuel et épaisseur)

Quantité : 3 Date : 7/11/14 Sceau : 

Quantité : \_\_\_\_\_ Date : \_\_\_\_\_ Sceau : \_\_\_\_\_



Date: Jeudi, 2014-11-06 11:50:16  
Utilisateur: Véronique Bouchard

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 65456

Nom Dessin: COVER ASSY  
Numéro: DKC135-0001

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

3.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Trimage de finition

Faire le découpage primaire sur la scie à ruban.

Faire le trimage de la pièce selon la ligne tracée sur le moule (elle doit apparaître sur la pièce) et selon le dessin page 21 (Pour les trous).

Autocontrôle de fabrication. (Visuel et selon le moule)

Déburrer.

Quantité : 3 Date : 10-11-14 Sceau :

Quantité : \_\_\_\_\_ Date : \_\_\_\_\_ Sceau : \_\_\_\_\_

4.0

AMB0209

Lexan 9034 transparent 0.060" thickness

Comment Qty.: 0.001 FEUILLE(s)/Unit Total : 0.003 FEUILLE(s)

Lexan 9034 0.060" thickness

N° de Lot : 4794410 AA

5.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Taillage du matériel.

Sur la banc scie, tailler les B30-2300-221 selon les dimensions du dessins (1.65" x 2.20") et faire des rayons de .20" au quatre coins.

Ébavurer.











Autocontrôle de fabrication. (Visuel et selon le dessin)

Quantité : 3 Date : 10-11-14 Sceau :

Quantité : \_\_\_\_\_ Date : \_\_\_\_\_ Sceau : \_\_\_\_\_

Date: Jeudi, 2014-11-06 11:50:16  
Utilisateur: Véronique Bouchard

## Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	COVER ASSY
Numéro Job:	65456	Numéro	DKC135-0001
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
6.0	AAC0562	3549 B/A adhesive kit 2oz.	
Comment	Qty.: 0.01 UNITE(s)/Unit Total: 0.03 UNITE(s)		
	3549 B/A adhesive kit 2oz.	N° de Lot: <u>484401 AA</u>	
7.0	PRÉPARATION.	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs		
	Faire le mélange de l'adhésif 3549 B/A selon les instructions inscrites sur le contenant.		
	Date: <u>11-10-14</u>	Sceau:	
8.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs		
	Assemblage général des pièces		
	Assembler les deux B30-23000-221 Window sur le B30-23000-219 à l'aide de l'adhésif 3549 B/A et laisser sécher pendant 16 heures.		
	Autocontrôle de fabrication. (Assemblage)		
	Quantité: <u>2</u>	Date: <u>13-11-14</u>	Sceau: 
	Quantité: _____	Date: _____	Sceau: _____
9.0	INSPECTION	Inspection générale	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs		
	Faire l'inspection de la pièce selon le dessin.		
	Quantité: <u>3</u>	Date: <u>14-11-14</u>	Sceau: 
	Quantité: _____	Date: _____	Sceau: _____

Date: Jeudi, 2014-11-06 11:50:16  
Utilisateur: Véronique Bouchard

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 65456

Nom Dessin: COVER ASSY  
Numéro: DKC135-0001

Numéro Job:



# Séq.:      Machine ou Opération:      Description :

10.0      IDENTIFICATION      Identification des pièces



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Identification des pièces.


Faire l'identification : N° de pièce : D3119-041


Date de fabrication : 14-11-14

N° de Work Order: 65456

Sceau d'inspection

Autocontrôle de fabrication. (Visuel de l'identification)

Quantité : 3      Date 14-11-14      Sceau : 

Quantité :      Date :      Sceau :      

11.0      EMBAL / ENTREPO      Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Emballer et entreposer les pièces selon IG 0057.

Quantité : 3      Date 14-11-14      Sceau : 